



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4085-3
Job Sheet 204933



Part No: D4085-3

Job Qty: 12 pcs

Part Name: Placard



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/23/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 1/10/20

Description:

Type: Stock

Note: DWG REV C IPP Rev:A 10.08.18 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Workcenter / Supplier Lead Time
					Setup Hrs	Run Hrs		
100	Purchasing	12 pcs	1/10/20	1/10/20	0.00	0.00	Purchasing - 1	Sign-off JAN 10 2020
					x 12		Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	12 pcs	1/10/20	1/10/20	0.00	0.00	Packaging 2 - 1 - B4B	JAN 10 2020
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



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CANADA
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Container No: S246256



Part: D4085-3

Job No: 204933

Serial No/Batch: S246256

Revision:

Inspector:

Exp Date: 01/09/2021

Instructions: Various STC's

Date: 01/10/20

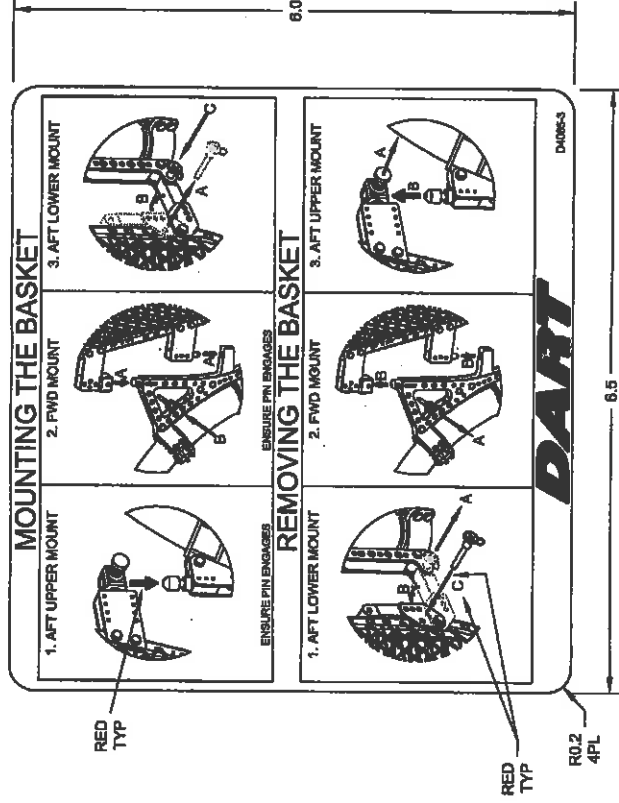
120 QC 6	12 pcs	1/10/20	0.00 0.00	Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS
				QC 6 - 40	81 JAN 14 2020
				QC 6 - 81	9-89
130 Packaging 3-1 - Stock - B4B	12 pcs	1/10/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	DAS
				Packaging 3 - 23 - B4B	84 51074
				Packaging 3 - 24 - B4B	9-89
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	12 pcs	1/10/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 JAN 14 2020
				QC 21 - SA - 53	9-89

Part Op 100 - (Purchasing) Issue P/O: _____
Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs)
120 - (QC6- All purchased or subcontracted products)
130 - (Identify as per dwg & Stock Location: _____) ***ONE YEAR EXPIRED DATE FROM RECEIVING: _____
140 - (QC21- Final Inspection - Work Order Release)

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Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D4085-3P	Placard, Instructions	12 pcs (1 ea)	100-Purchasing	S246254
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D4085-3P	12	0	0
Part Specifications				
Specifications could not be found.				

Plex 12/23/19 11:25 AM Dart.lajeunesse.marie



D4085-3 PLACARD, INSTRUCTIONS

- NOTES:
- 1) MATERIAL: BLACK LETTERS AND GRAPHICS WITH RED ARROWS AND LOGO ON WHITE BACKGROUND AND ADHESIVE BACK. MANUFACTURED FROM 3M, 7 MIL MASKING FILM #9522CP OR AVERY IPM #2031
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) USE FILE D4085-3C.eps FOR GRAPHICS

RELEASED
2010-07-18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2014911

1972-23

DESIGN	IPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO.
MFG. APPR.	N/A	D4085
APPROVED		TITLE
DE APPR.		PLACARD, INSTRUCTIONS
DATE	10.06.25	SCALE
		NTS

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045484



Supplier: STU002-VC
Studio de Lettrage 2001
210 Main West
Hawkesbury
ON
K6A 2H6 Canada
Phone: 613 632 5449
Fax: 613 632 9491

Attention: Grace, Batista

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045484
PO Date: 1/2/20
Due Date: 1/13/20
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

2020-01-02

MAILED

Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	204933	D4085-3P	D4085 Rev C			Placard, Instructions : AS PER DWG D4085 REV. C	Firmed X12	-	1/13/20	12 pcs	0 pcs	12 pcs	\$6.6666/pcs	\$80.00
													JAN 10 2020	
2	205175	D4384-1P	D4384 Rev A	D4384-1P		Placard : AS PER DWG D4384 REV. A	Firmed X24	-	1/13/20	24 pcs	0 pcs	24 pcs	\$6.6666/pcs	\$160.00
													JAN 10 2020	
Grand Total:														\$240.00

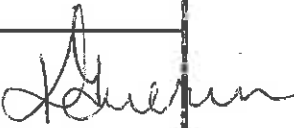
Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY

A015 SHELF LIFE CONTROLLED MATERIAL,60% SHELF LIFE REQUIRED AT RECEIPT
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A032 DOCUMENT SPECIAL REQUIREMENTS
A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS



Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an Integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

*** CERTIFICATE of CONFORMITY***				
Manufacture: <u>Studio SL2</u>				
Purchase order #:	Packing Slip#	Part #:	Drawing Rev:	Serial/Batch:
<u>H8045484</u>	<u>WO#26562</u>			
Description (Part Name): <u>D4085-3P, D4384-1P.</u>			Quantity: <u>12, 24</u>	
Certification: We hereby certify that:				PLEASE CHECK BOX IF REQUIRED
1. The above listed items were manufactured and/or inspected in accordance with applicable supplied drawings and/or specifications.				☒
2. All work was accomplished in accordance with the Dart Aerospace Ltd. purchase order.				☒
3. Results of all inspections, chemical or physical test, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.				☒
4. All material certification or copies of purchase orders of the material used to manufacture this component have been attached to this document.				☒
Record Expiry Date of Materials: <u>Jan 09, 21</u>				
Authority: <u>3m</u>				
Approval:		Date: (yyyy/mm/dd)		
<u>Valerie Yang</u>		<u>2020/01/09</u>		
Signature:		Title:		
<u>Val - 2</u>		<u>Account Manager</u>		

Studio SL2
210 Main West
Hawkesbury, Ontario K6A 2H6
Canada

INVOICE

Invoice No.: 49180
Date: 12/31/2019
Ship Date:
Page: 1
Re: Order No.

Sold to:
Dart Aerospace Ltd

1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Ship to:
Dart Aerospace Ltd

1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Business No.: 825007651RT0001

Quantity	Description	Tax	Base Price	Disc %	Unit Price	Amount
12	D4035-3P	H	6.6667		6.6667	80.00
24	D4384-1P	H	5.0000		5.0000	120.00
	PO# HB045484					
	Attn: Kim G					
	Subtotal:					200.00
	H - HST					
	HST					26.00
Studio SL2 HST: #HST						
Shipped By: Tracking Number:					Total Amount	226.00
Comment: WO26562					Amount Paid	0.00
Sold By:					Amount Owing	226.00

RECEIVED
JAN 10 2020
DART AEROSPACE LTD.

IJ35-10
IJ35-20

Quick Links

[3M Graphics Warranties](#)
[Technical Information Selector](#)
[Safety Data Sheets \(SDS\)](#)
[Flammability \(ASTM E84 Reports\)](#)
[Videos](#)

Product Description

- For Solvent, Eco-Solvent UV and Latex Inkjet Printing and Screen Printing
- 3.2-mil vinyl film

Product Features

- Available in gloss and matte finishes
- Pressure-sensitive adhesive
- Permanent
- Expected Performance Life of 5 years (unwarranted period for unprinted film with no graphic protection, applied to a flat, vertical, outdoor surface)

Recommended Types of Graphics and End Uses

- Short to long-term, indoor and outdoor promotional graphics
- Signs, trade show and point-of-purchase displays
- Exhibits and architectural applications

Graphic Protection

Graphic protection can improve the appearance, performance and durability of your graphic. Always use only the graphic protection options recommended in this Bulletin for this film.

- [3M™ Scotchcal™ Gloss Overlaminate 8508](#)
- [3M™ Scotchcal™ Luster Overlaminate 8509](#)
- [3M™ Scotchcal™ Matte Overlaminate 8510](#)

Characteristics

These are typical values for unprocessed product. Processing may change the values.

Physical Characteristics

Characteristic	Value
Material	Vinyl
Film Color	White, opaque
Thickness	Without adhesive: 3.25 mil (0.081 mm) With adhesive: 4.0 mil (0.102 mm)
Adhesive	Pressure sensitive
Adhesive Color	Gray
Liner	Polycoated paper
Flammability	ASTM E84 reports: IJ35-10 and IJ35-20 , or go to the On-line Product Catalog at 3Mgraphics.com

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Application Characteristics

Characteristic	Value
Finished Graphic Application Recommendation	Surface type: Smooth, flat and simple curved surfaces Substrate type: Metal, rigid plastic and painted surfaces Application temperature: 40° – 100°F (4° – 38°C) air and substrate Application method: Dry
Temperature Range After Application	-59 °F to +192 °F (-50 °C to +90 °C) (not for extended periods of time at the extremes)
Graphic Removal	Permanent

Warranty Information

Warranty Coverage Overview

The warranty coverage for eligible graphics is based on the user both reading and following all applicable and current 3M Graphics Product and Instruction Bulletins. The warranty period for eligible graphics is as stated in the 3M Graphics Warranties Matrices at the time that the film was purchased. Information found at [3MGraphics.com/warranties](https://www.3m.com/graphics/warranties) includes:

- [3M Graphics Warranties Bulletin](#)
 - This bulletin contains information on limitations and exceptions, and warranty period reductions for 3M Graphics Warranties. The warranty period may be reduced and stipulations may apply for certain constructions, applications, and graphic exposures as covered in this Bulletin.
- [3M Graphics Warranties Selector](#)
 - Use this selector to search for your vertical warranty period by product type, ink type, film name, and/or ink/prINTER platform.
- [U.S. Desert Southwest Region Map](#)
 - Use this map of hot, arid desert areas to determine if you are subject to reduced warranted durabilities.

The warranties set forth in this Bulletin are made in lieu of all other express or implied warranties, including any implied warranty of merchantability, fitness for a particular purpose, or arising out of a course of dealing, custom, or usage of trade.

3M Basic Product Warranty

3M Graphics Products are warranted to be free of defects in materials and manufacture at the time of shipment and to meet the specifications stated in its applicable 3M Graphics Product Bulletin and as further set forth in the [3M Graphics Warranties Bulletin](#).

Limited Remedy

The limited remedy applicable to each warranty is addressed in the 3M Graphics Warranties Bulletin found at [3MGraphics.com/warranties](https://www.3m.com/graphics/warranties).

Limitation of Liability

Except where prohibited by law, 3M SHALL NOT UNDER ANY CIRCUMSTANCES BE LIABLE TO PURCHASER OR USER FOR ANY DIRECT (EXCEPT FOR THE LIMITED REMEDY PROVIDED IN THE 3M GRAPHICS WARRANTIES BULLETIN), INDIRECT, SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES (INCLUDING, BUT NOT LIMITED TO, LABOR, NON-3M MATERIAL CHARGES, LOSS OF PROFITS, REVENUE, BUSINESS, OPPORTUNITY, OR GOODWILL) RESULTING FROM OR IN ANY WAY RELATED TO 3M'S GRAPHICS PRODUCTS, SERVICES, or THIS BULLETIN. This limitation of liability applies regardless of the legal or equitable theory under which such losses or damages are sought.

Additional Limitations

See the 3M Graphics Warranties Bulletin at [3MGraphics.com/warranties](https://www.3m.com/graphics/warranties), for terms, additional limitations of your warranty, if any, information on reduced warranties for different exposures, and limitations of liability.

Factors that Affect Graphic Performance Life

The actual performance life of a graphic is affected by:

- the combinations of graphics materials used.
- complete ink drying or curing.
- selection, condition and preparation of the substrate.
- surface texture.
- application methods.
- angle and direction of sun exposure.
- environmental conditions.
- cleaning or maintenance methods.

Graphics Manufacturing



CAUTION

Before using any equipment, always read the manufacturer’s instructions for safe operation.

Inkjet Printing

Always read and follow the ink manufacturer’s written instructions on usage.

- **Sheeted film:** When used on a flat-bed inkjet printer, sheeted film may produce printing defects.
- **Ink limiting:** The recommended maximum ink limit is 250%.
- **If sheeted or stacked graphics will be stored:** If you plan to store sheeted and stacked finished graphics for an extended period of times, leave an unprinted margin (about 1/4 inch) to allow for possible shrinkage before trimming the graphic.

Do not exceed the recommended total ink coverage for the ink series used on this film. Having too high a total physical ink amount on the film results in media characteristic changes, incomplete drying, overlamine lifting, and/or poor graphic performance.

Completely Dry Graphics



IMPORTANT NOTE

Incomplete drying or curing can result in graphic failure including curling, increased shrinkage and adhesion failure, which are not covered under any 3M Graphic Warranty.

See the ink’s 3M Product and Instruction Bulletin for more details.

Screen Printing

Formulations and processing conditions can affect ink durability. Refer to the Product and Instruction Bulletins for your ink for limitations and proper usage.

Cutting

See [3M Instruction Bulletin 4.1](#) for Sheeting, Scoring and Film Cutting details.

Graphic Protection

Graphic protection may improve the appearance, performance and durability of the graphic. Click on the graphic protection options listed in Product Bulletin or see the [3M Graphics Market Product Catalog](#), for more information.



IMPORTANT NOTE

During installation, scratches may occur on films without graphic protection.

Application and Installation

In addition to other 3M Bulletins specified in this document, the following Bulletins provide details that you may need to successfully apply a graphic.

- [3M Instruction Bulletin 4.22](#). Hot and Cold Roll Lamination for 3M Overlaminates.
- [3M Instruction Bulletin 5.1](#) Select and Prepare Substrates for Graphic Application
- [3M Instruction Bulletin 5.19](#). Lamination, Application & Maintenance of Floor Graphics. Complete the Surface Preparation procedure found in this Instruction Bulletin prior to applying a graphic to a surface.
- [3M Instruction Bulletin 5.5](#) Application, General Procedures for Interior and Exterior Dry Application
- [3M Instruction Bulletin 6.5](#) Storage, Handling, Maintenance, and Removal of Films and Sheetings

Pressure-sensitive Adhesive

This film has a pressure-sensitive adhesive. It bonds to the surface even with light pressure and cannot be repositioned.

Maintenance and Cleaning

Use a cleaner designed for high-quality painted surfaces. The cleaner must be wet, non-abrasive, without solvents, and have a pH value between 3 and 11 (neither strongly acidic nor strongly alkaline). See [3M Instruction Bulletin 6.5](#) for details.

Shelf Life, Storage and Shipping

Shelf Life

The shelf life is **never more than 2 years** from the date of manufacture on the original box.

If you process the film, the shelf life is changed to **1 year** from the processing date, but not later than the 2 year maximum from the manufacturing date.

Storage Conditions

- 90 °F (32 °C) maximum
- Out of sunlight
- Clean, dry area
- Original container
- Bring the film to print room temperature before using

Shipping Finished Graphics

Flat, or rolled printed side out on 5 inch (13 cm) or larger core. This helps prevent the liner, if used, from popping off.

Health and Safety



CAUTION

When handling any chemical products, read the manufacturer's container labels and the Safety Data Sheets (SDS) for important health, safety and environmental information. To obtain SDS sheets for 3M products go to [3M.com/SDS](https://www.3m.com/SDS), or by mail or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturer's instructions for safe operation.

Bulletin Change Summary

For the most current 3M Technical Information available to successfully use this product, please view this Bulletin electronically and click on the blue underlined links to view the relevant documents.

Release J, NOV-2016:

- Updated Thickness. See “Physical Characteristics” on page 1.

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1-800-265-1840
Fax 519-452-6245

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Col. Santa Fe, Del. Alvaro
Obregón
México D.F. 01210
General 5255-5270-0400
Fax 5255-5270-2277

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San Juan, PR 00918
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